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D4379-5

Job Sheet 200217



Part No: D4379-5

Job Qty: 50 pcs

Part Name: Wearplate Cup



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/9/19

Job Tracking No:

Due Date: 10/7/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEET 3 IPP REV:A NEW ISSUE 14-04-01 JLM VERIFIEWD BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	50 pcs	10/7/19	10/7/19	1.00	4.17	Doosan - 1		19/09/27
120	QC 8	50 pcs	10/7/19	10/7/19	0.00	0.00	QC 8 - 12		m/19/09/28
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Packaging 3-1 - Stock - B4B	50 pcs	10/7/19	10/7/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

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DAS
65
9-89

					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	ER
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	50 pcs	10/7/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-88

Part Op 100 - Doosan Lathe - turn as per Dwg and folio FB300

SEP 30 2019

Descriptions: 120 - QC8- Inspect parts - second check

130 - Identify as per dwg & Stock LOCATION: WA001-15

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.000	304 Round Bar 1.00	2.4000 ft (.048 ea)	100-Doosan - 1	\$167687 2190202

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M304R1.000	2	22	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate Cup	0.875Inches + 0.000 - 0.005	0.875 0.870	Diameter	
2	Wearplate Cup	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	
3	Wearplate Cup	0.466Inches ± 0.010	0.476 0.456		
4	Wearplate Cup	0.353Inches ± 0.010	0.363 0.343		
5	Wearplate Cup	0.031Inches ± 0.010	0.041 0.021		
6	Wearplate Cup	45.000Degrees ± 0.500	45.500 44.500	Angle	
7	Wearplate Cup	0.200Inches ± 0.010	0.210 0.190		
8	Wearplate Cup	0.507Inches ± 0.010	0.517 0.497		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐		MRB (QS1042) ☐ ☐ ☐ ☐ ☐					
Date : _____		Sequence #: _____		QTY Affected : _____		MRR (QS1042) ☐ ☐ ☐ ☐ ☐					
Description Work Order Deviation				Disposition							
Completed By				Lead hand / Supervisor							
								QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Power Loss/Surge ☐ Follo/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			